

# Work Order ID 52324

Tuesday, September 22, 2009 3:09:30 PM

Page 1

Item ID: D3405-043  
Revision ID: B  
Item Name: Lug Assembly

Accept

Setup Start  
Stop

Start Date: 9/23/2009 Start Qty: 12.00  
Required Date: 10/9/2009 Req'd Qty: 12.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: PL Date: 8/29/24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

364  
.125

B 9-10-13

(15)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-10-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 8/10/13

(15)



**Work Order ID 52324**

Tuesday, September 22, 2009 3:09:30 PM



Page 2

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

8/29/10/19

Deburr Form using DT8204 as per Dwg D3405

Brake NC

140



QC

QC5- Inspect part completeness to step on W/O

0.00

8/29/10/19

Memo

0.00

split @ 12

Quality Control

150



Large Fab

Large Fab

0.00

Memo

0.00

Weld as per Dwg D3405 Identify as D3405-043

Large Fab

9-10-21



# Work Order ID 52324

Tuesday, September 22, 2009 3:09:30 PM



Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Item Name: Lug Assembly

Stop



Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*Pl 09 10 21*

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*2) Sorkolzi*



*p*

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *10:45am* OVEN TEMPERATURE:  
FINISH TIME: *11:15am* *400F*

*7 09/10/21*



*8*





**Work Order ID 52324**

Tuesday, September 22, 2009 3:09:30 PM



Page 4

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

BR 09-10-21

12



QC

Memo

0.00

Quality Control

200

Identify as per dwg &amp; Stock Location: 474

0.00



Packaging

Memo

0.00

Packaging

9/10/23 120 84

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-10-24





# Picklist Print

Page 1

Tuesday, September 22, 2009 3:09:30 PM

Work Order ID: 52324



Parent Item: D3405-043RevB



Parent Item Name: Lug Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1RevC		Manufactured	No			100	Each	63.0000	12.0000			



GHW Lug



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

52515 x 12

- BL 9-10-21

ST

63

45372

8

50471

25

51548

30

M304S11GA

Purchased

No

150

sf

132.3156

1.9453

2.4316



304/316 0.125 Sheet

RB 9-10-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

132.3155979

111018

4.31559789

112663

128

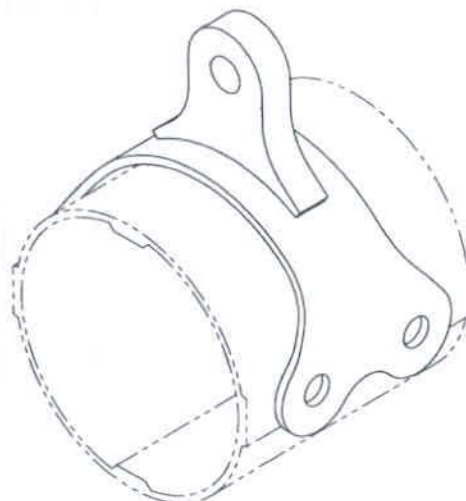
111018



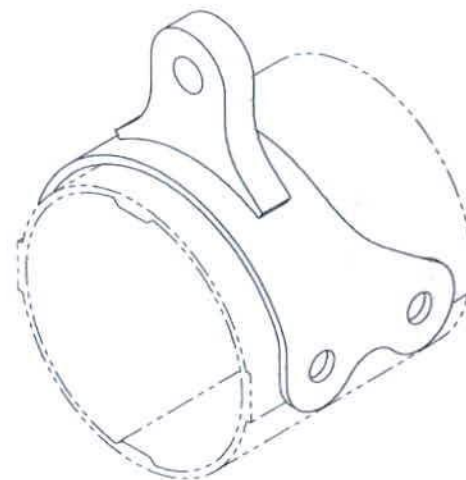
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52324



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

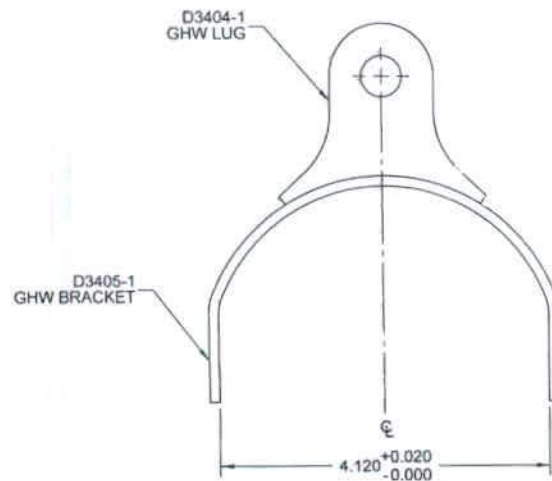
**RELEASED**  
05/12/18 M.P.

**NOTES:**

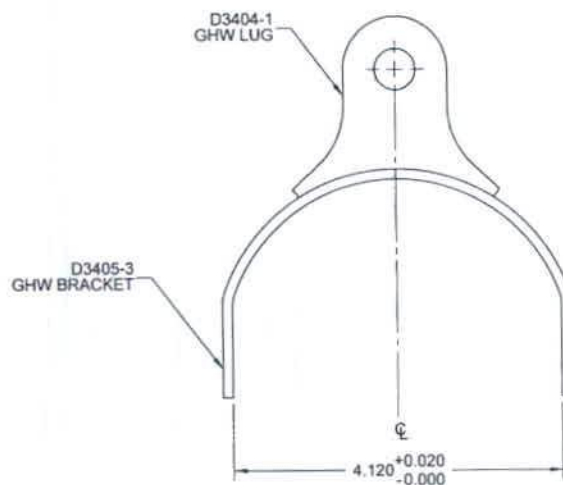
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

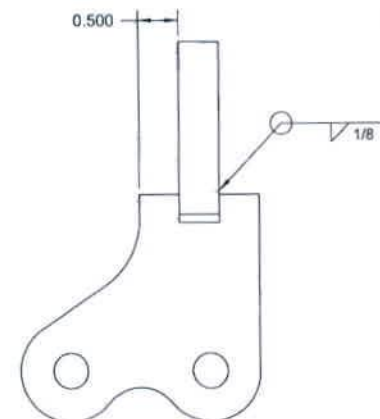
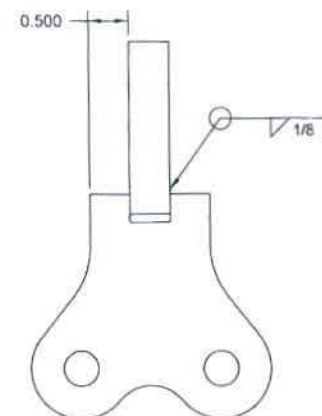




**D3405-041 LUG ASSEMBLY**



**D3405-043 LUG ASSEMBLY**



52324

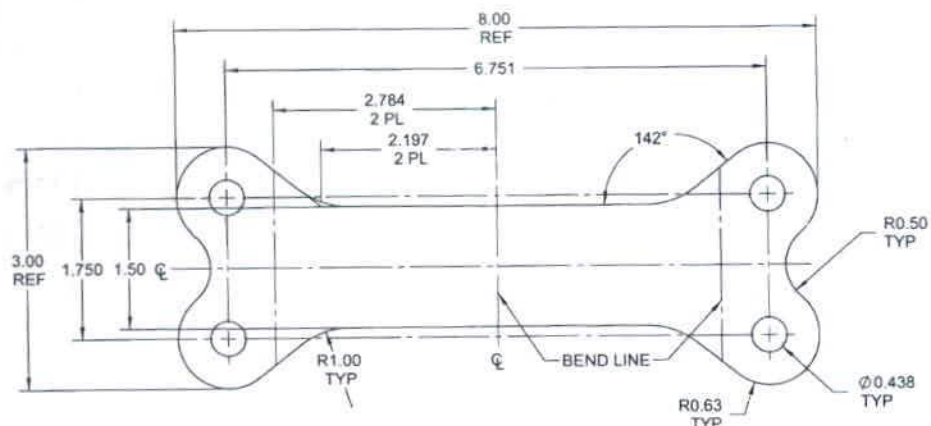
**RELEASED**  
6/12/18

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3405</b>	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>GHW LUG ASSEMBLY</b>	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

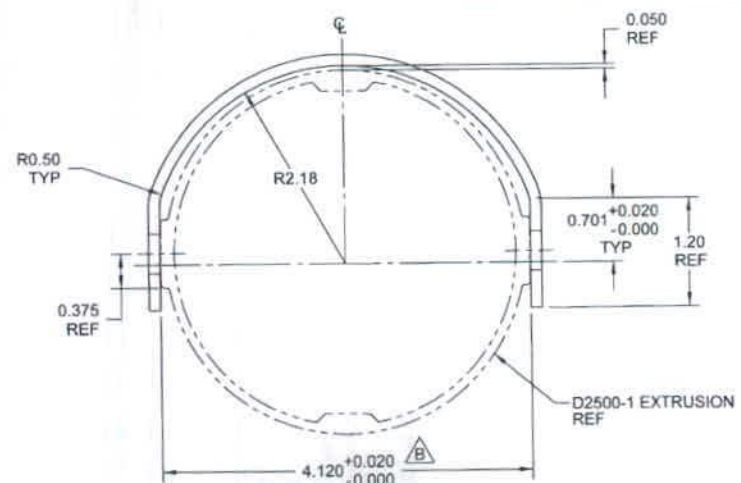




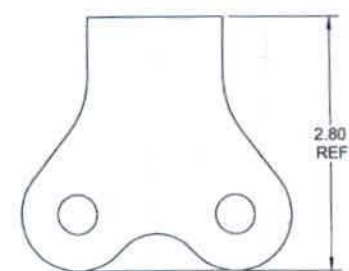
52324



**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



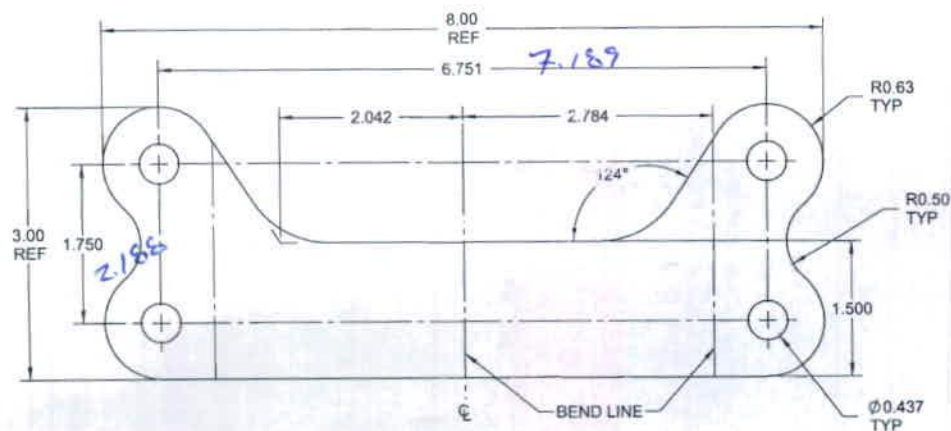
SIDE VIEW FOR REF ONLY

**RELEASED**

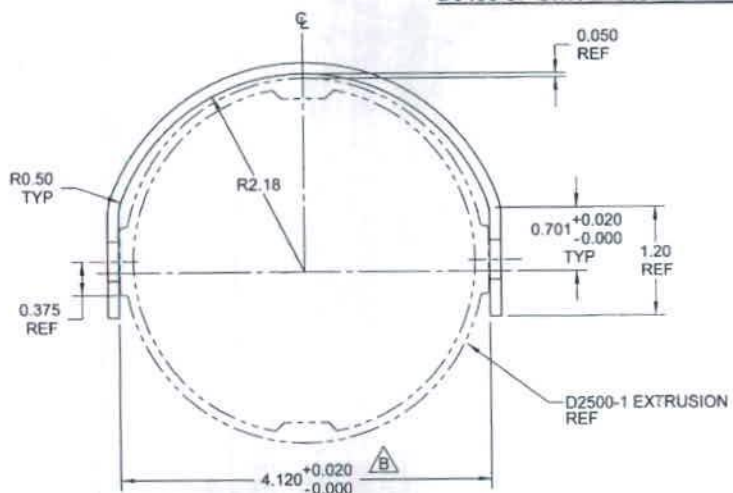
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE KEPT TO BE USED FOR ANY PURPOSE OR COMMUNICATION TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

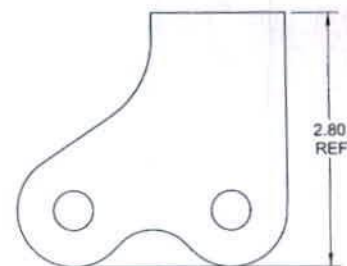




**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED, REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
08/12/14





